

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 120921

Friday, June 13, 2014 2:22:18 PM

120921

Page 2

Item ID: D4463-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Top Assembly
Start Date: 6/16/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/20/14 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	NC BRAKE Memo C'SINK HOLES AS PER DWG	0.00 0.00				<u>4X</u>			<u>14/06/17</u>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>4</u>			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>4</u>			<u>16/06/17</u>

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Equip/Tooling									
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Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

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Work Order ID 120921

Friday, June 13, 2014 2:22:18 PM

120921

Page 3

Item ID: D4463-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tank Top Assembly

Stop

NS2

Start Date: 6/16/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/20/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

4 0 14/06/18
DAS
19
9-89

170

0.00

170

Small Fab

Memo

0.00

Small Fab

INSTALL ANCHOR NUTS AS PER DWG

4x 14/06/19
DAS
3F
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

y 14/6/19

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Work Order ID 120921

Friday, June 13, 2014 2:22:18 PM

120921

Page 4

Item ID: D4463-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tank Top Assembly

Stop

NS2

Start Date: 6/16/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/20/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: WMA, CO3 0.00***190***

Packaging

Memo

0.00

Packaging

4 0 14.06.19

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

14/6/23 MF 14-6-19

DQA: _____ Date: _____



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Picklist Print

Friday, June 13, 2014 2:22:26 PM

Page 1

Work Order ID: 120921

120921

Parent Item: D4463-041

D4463-041

Parent Item Name: Tank Top Assembly

Start Date: 6/16/14

Required Date: 6/20/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC
12.04.25 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

498.0880

3.864

(17)

DAS

M6061T6S 063

6061-T6 .063 Sheet

**

23
9-89

14-06-17

Location

Loc Qty

Loc Code

MAT021

498.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

79.768

M128941

284

128941

MS20426AD3-4

Purchased

No

170

Each

6,918.000

48

192

DAS

MS20426AD3-4

RIVET

**

36
9-89

14/06/19

Location

Loc Qty

Loc Code

MF4

265

125578

265

ST334

2917

m127432

2917

ST509

3736

125578

3736

192

NAS1473R3

Purchased

No

170

Each

358.0000

24

96

DAS

NAS1473R3

Anchor Nut

**

36
9-89

14/06/19

Location

Loc Qty

Loc Code

GA

358

m127059

233

m127813 -

125

1

95

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

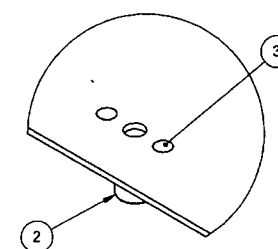
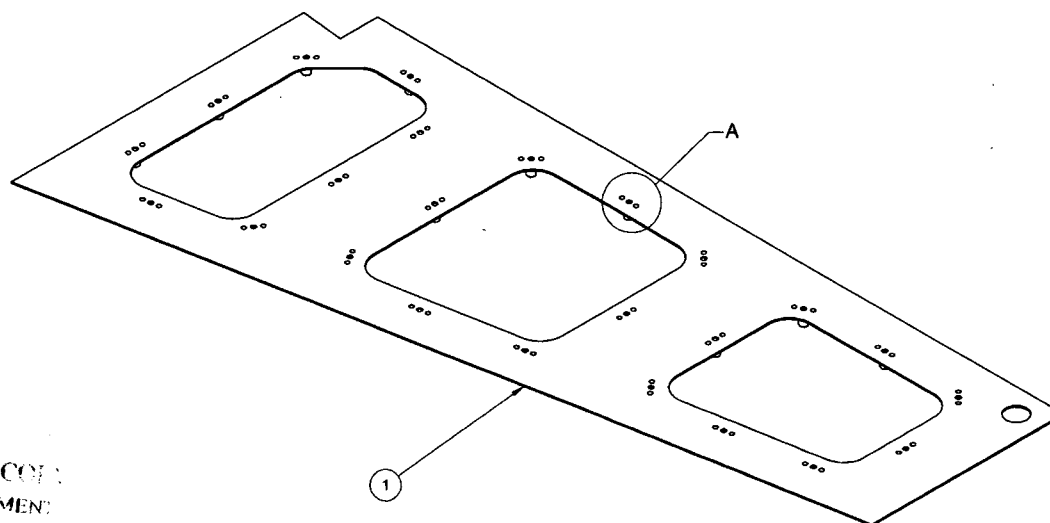
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
	X	D4463-041	TANK TOP ASSEMBLY
1	1	D4463-1	TANK TOP
2	24	NAS1473-3	ANCHOR NUT
3	48	MS20426AD3-4	RIVET, CSK



DETAIL A
24 PL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120921MP
14-6-13

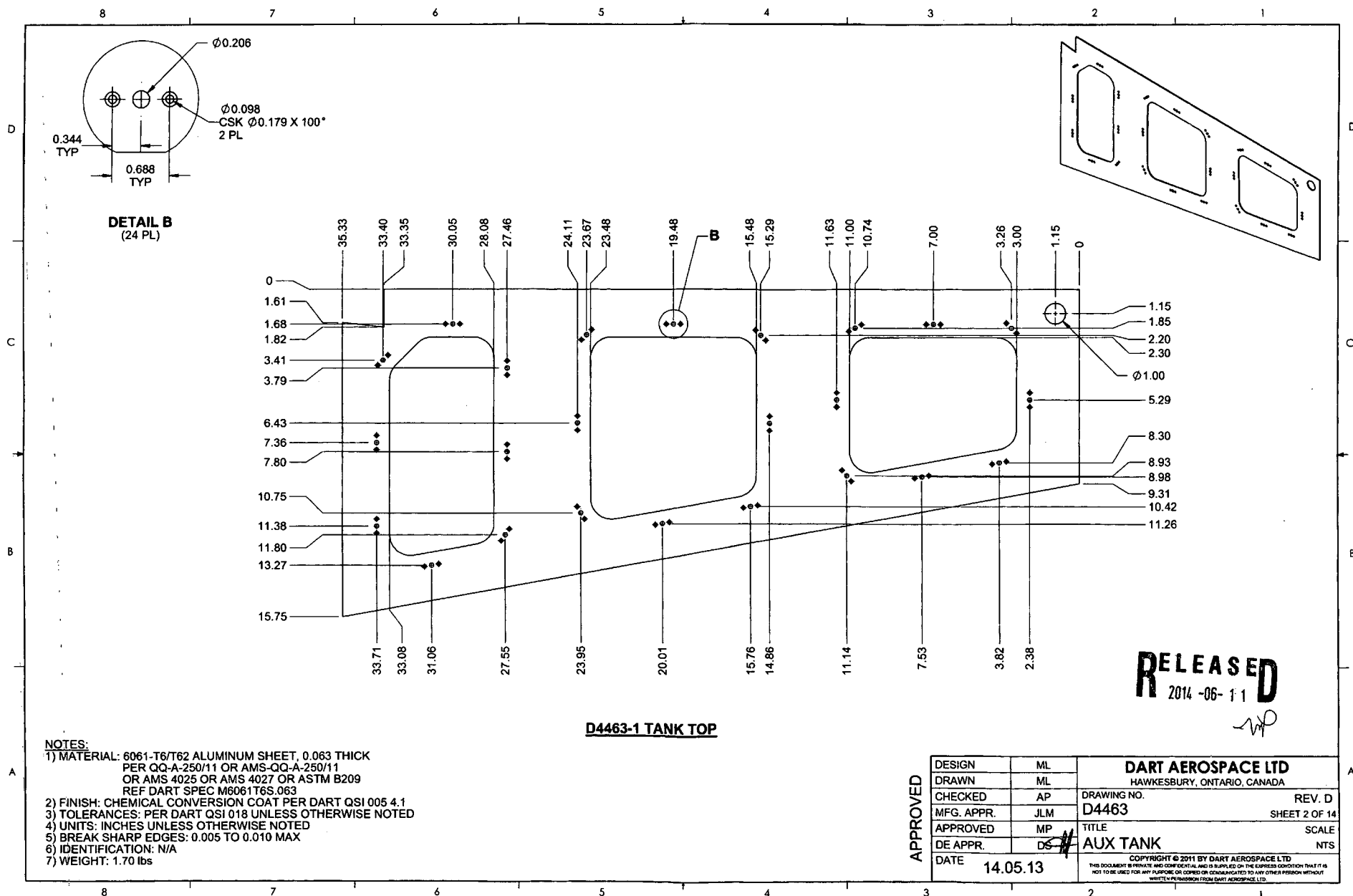
D4463-041 TANK TOP ASSEMBLY

RELEASED
2014-06-11

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.77 lbs

D	ADDED RIVET PILOT HOLES TO D4463-9/-11 SHEET 9-12 REF NCR 13-3100 UPDATED D4463-3F (B3-4)	ML	14.05.13
C	ADD DIMS: ZN B5-5, D5-5, B2-11, B7-11, D3-11, ADD -13, MODIFY -1/-11.	DC	12.03.23
B	ADD D4463-041, ZN C5-1, UPDATED -1/-3/-5/-7/-9, COMBINED -11 & -13 INTO -11.	DC	11.12.14
A	NEW ISSUE	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4463	SHEET 1 OF 14
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	AUX TANK	NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



DART AEROSPACE LTD		Work Order:	120921
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098"	-		V	Jkmos
Ø0.206	+0.005/-0.001	0.206"	-		V	
Ø1.00	+0.012/-0.001	1.003"	-		V	
1.15	+/-0.030	1.15"	-		V	
1.85	+/-0.030	1.85"	-		V	
2.20	+/-0.030	2.20"	-		V	
2.30	+/-0.030	2.30"	-		V	
5.29	+/-0.030	5.29"	-		V	
8.30	+/-0.030	8.30"	-		V	Jkmos
8.93	+/-0.030	8.93"	-		V	
8.98	+/-0.030	8.98"	-		V	
9.31	+/-0.030	9.31"	-		V	
10.42	+/-0.030	10.42"	-		V	
11.26	+/-0.030	11.26"	-		V	
1.61	+/-0.030	1.61"	-		V	
1.68	+/-0.030	1.68"	-		V	
1.82	+/-0.030	1.82"	-		V	
3.41	+/-0.030	3.41"	-		V	
3.79	+/-0.030	3.79"	-		V	
6.43	+/-0.030	6.43"	-		V	
7.36	+/-0.030	7.36"	-		V	
7.80	+/-0.030	7.80"	-		V	
10.75	+/-0.030	10.75"	-		V	
11.38	+/-0.030	11.38"	-		V	
11.80	+/-0.030	11.80"	-		V	
13.27	+/-0.030	13.27"	-		T	
1.15	+/-0.030	1.15"	-		V	
3.00	+/-0.030	3.00"	-		V	
3.26	+/-0.030	3.26"	-		V	
7.00	+/-0.030	7.00"	-		V	
10.74	+/-0.030	10.74"	-		V	
11.00	+/-0.030	11.00"	-		V	
11.63	+/-0.030	11.63"	-		V	
15.29	+/-0.030	15.29"	-		T	
15.48	+/-0.030	15.48"	-		T	
19.48	+/-0.030	19.48"	-		T	
23.48	+/-0.030	23.48"	-		T	
23.67	+/-0.030	23.67"	-		T	
24.11	+/-0.030	24.11"	-		T	
27.46	+/-0.030	27.46"	-		T	

